

Work Order ID 78351

Thursday, January 05, 2012 3:22:08 PM

78351

Page 1

Item ID: D4005-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rear Restraint Angle Gutter
Start Date: 1/6/2012 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/27/2012 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: mf Date: 12-01-06 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4005	A								

100 0.00

100

Waterjet Memo 0.00 B12-1-10

FLOW CNC Waterjet

2004.063

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

(10)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.00 B12-1-10

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		812/01/10		(10)			
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00		SB 12/01/20		(10)			
135 *135* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		812/01/26		(10)			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140 Chemical Conversion Coat per QSI005 4.1 0.00

140

HandFinish

Hand Finishing

Memo

0.00

10 BR 12-1-30

150 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

150

Powdercoat

Powder Coating

Memo

Start Time: 9:20

Oven Temperature: 320°F

Finish Time: 9:50

0.00

10 X 1/2 m / 12/02/01

160 QC3- Inspect Part Finish 0.00

160

QC

Quality Control

Memo

0.00

10 BR 12-2-1

W/O:		WORK ORDER CHANGES					
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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Restraint Angle Gutter

Start Date: 1/6/2012 Start Qty: 5.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

164

0.00

164

Small Fab

Memo

0.00

Small Fab

1-Install abrasion strip and trim excess as per dwg

EP 12/02/01 (10)

166

QC5- Inspect part completeness to step on W/O

0.00

166

QC

Memo

-0.00

Quality Control

5 12/02/02

(416)

170

Identify as per dwg & Stock Location: 106

0.00

170

Packaging

Memo

0.00

Packaging

12/2/2 (10) \$0

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 1/6/2012 **Start Qty:** 5.00

5

Customer:

Required Date: 1/27/2012 Req'd Qty: 5.00

5

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool

Plan Code

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/2/3 ~~7~~
ME
12-02-02

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 78351

Parent Item: D4005-1

Parent Item Name: Rear Restraint Angle Gutter

Start Date: 1/6/2012

Required Date: 1/27/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP Rev:C 10.11.11 added abrasion strip DD verified by:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	219.0000	0.1451	0.7636842			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT022		219							
				117392		27							
				119916		192							
D2856-100-1100 Abrasion Strip cut one at 11.00"		Manufactured	No			164	Each	0.0000	1	5			

2
B12-1-10

117392

B73491

(10)
EP 12/02/01

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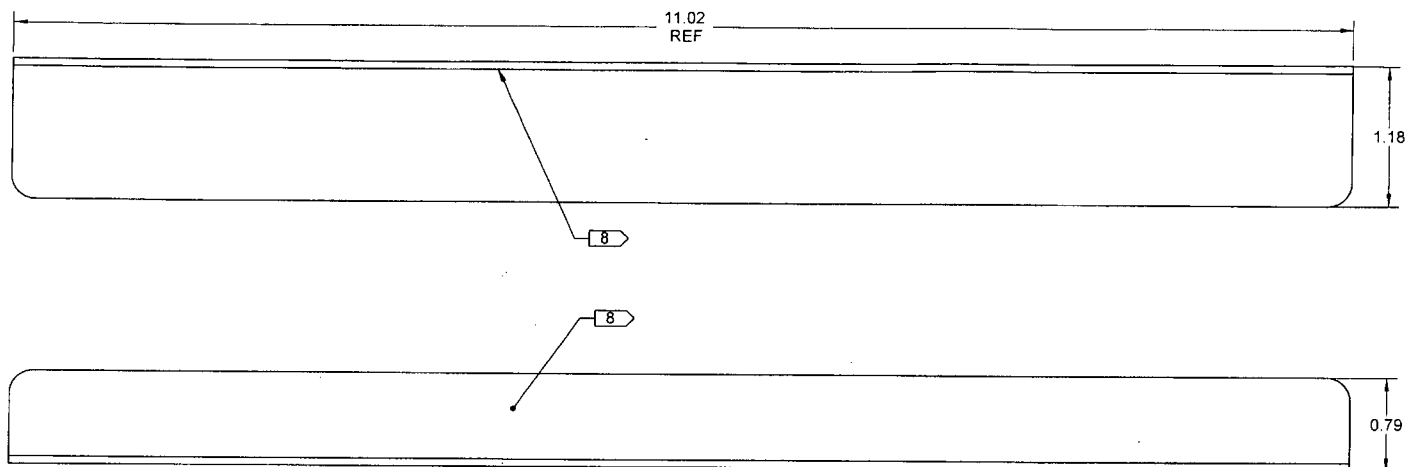
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-1	JCA-M47-2-03



D4005-1 REAR RESTRAINT ANGLE GUTTER

RELEASED
2010-05-05
WJP

NOTES:

- 1) MATERIAL: MADE FROM D4005-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.12 lbs
- 8) COVER THIS SURFACE WITH D2856-100-11 ABRASION STRIP. TRIM EXCESS

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4005
MFG. APPR.		REV. A
APPROVED		SHEET 2 OF 15
DE APPR.		TITLE RESTRAINT
DATE	10.02.05	SCALE
		NTS

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Dart Aerospace Ltd

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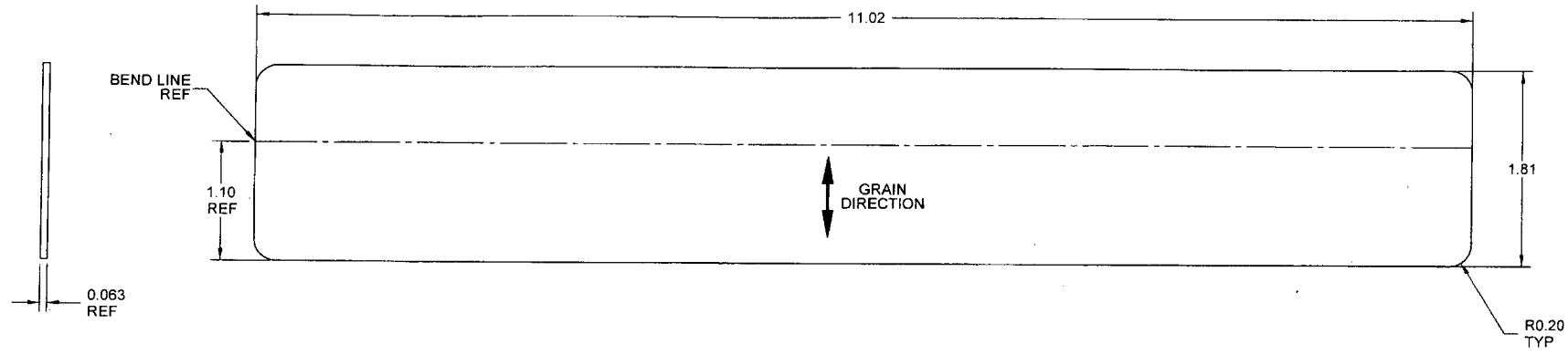
8 7 6 5 4 3 2 1

D D

C C

B B

A A



D4005-1F FLAT PATTERN

78351

RELEASED
R 2010-05-05 D
MP

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4005	SHEET 3 OF 15
APPROVED		TITLE	SCALE
DE APPR.		RESTRAINT	NTS
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8 7 6 5 4 3 2 1

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Eric Charbonneau

From: Harvey Siemens <hsiemens@dartaero.com>
Sent: January 27, 2012 9:18 AM
To: Eric Charbonneau
Cc: dcampbell@dartaero.com
Subject: D4005-1

Eric

It is permissible to include a 0.13 diameter hole 0.5" from the edge on the D4005-1 F part so that it can be hung in the powder coat oven.

Let me know if there is anything else that you need.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: hsiemens@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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